

CLAIM AMENDMENTS:**Claims 1 to 75 cancelled**

76. (amended) A device for producing a printed useful part and a waste portion residue by punching printed cardboard, cardboard packaging, corrugated board, paper and similar substrates using a rotary contour punching process adjustable to changed processing shapes, the device comprising:

a first rotating processing roller;

a second rotating processing roller, said second processing roller cooperating with said first processing roller to define a working gap between said first processing roller and said second processing roller;

tool parts disposed on at least one of said first processing roller and said second processing roller to process a useful part and a waste portion from the substrate by cooperating with at least one of said first processing roller and said second processing roller to punch out the substrate in said working gap ;

at least one mechanical gripper, with a spring type element, disposed on at least one of said first processing roller and said second processing roller, said at least one gripper effecting a register-controlled transport of the substrates as printed sheets by grasping and holding said substrate at the front edge, whereby the printed image and processing shape of the subsequent tool parts are thereby superposed in a register-controlled fashion and with improved accuracy;

means for splitting off and separating the useful part from the waste portion, wherein the means for splitting off and separating is disposed at the end of the working gap, wherein the means for splitting off and separating include said gripper and means for suctioning and/or pressurized air so that the waste portion is held and removed from

the working gap either by said gripper or by means of suctioning and/or pressurized air; and at least one disposal device, facing at least one of said first processing roller and said second processing roller, cooperating with the waste transport means using an airflow for collecting the waste portion.

77.(previously presented) The device of claim 76, wherein a downstream gripper acting on the substrate fed from the first processing roller and the second processing roller is disposed at any one of a delivery roller, a transfer roller, or a down stream arm.
(supported by PCT claim 4 and 19, page 17 line 17 and claim 29)

78.(previously presented) The device of claim 76, wherein at least the substrates without punching or with pre-punching are transported in a register controlled fashion.

(supported by PCT page 12 line 17 and page 13 line 1-4)

79.(previously presented) The device of claim 76 wherein the device is integrated in a processing line such that it is register controlled and at least an auxiliary device is provided in the work cycle of the processing line before or after the device.

(supported by PCT page 4, Fig. 14, Page 7 line 24 and Page 8 line 1-2)

80.(previously presented as PCT claim 45) The device of claim 76, wherein said first and said second processing rollers bear said tool parts in an exchangeable manner.

81.(previously presented as PCT claim 47) The device of claim 76, further comprising a laser punching unit disposed proximate said working gap.

82.(previously presented as PCT claim 46) The device of claim 76,

wherein said first and said second processing rollers comprise magnetic cylinders on which said tool parts are held in an exchangeable fashion, said tool parts comprising at least one of punching, stamping, furrowing and embossing tools.

83. (previously presented as PCT claim 48) The device of claim 76, further comprising a downstream disintegrating means.
84. (previously presented as PCT claim 49) The device of claim 83, wherein said disintegrating means cooperates with said disposal device via transport pipes.
85. (previously presented as PCT claim 50) The device of claim 84, wherein said disintegrating means is connected to a waste bin via transport pipes.
86. (previously presented as PCT claim 51) The device of claim 85, wherein said disintegrating means is disposed outside or inside a machine.
87. (previously presented as claim 52) The device of claim 76, wherein a plurality of disposal devices are provided for disposal of the waste portion.
88. (previously presented as claim 53) The device of claim 87, wherein said plurality of disposal devices are structured and positioned for disposal of the waste portion at a surface and/or inner portions of said first and said second processing rollers.
89. (previously presented as PCT claim 54) The device of claim 88, wherein said plurality of disposal devices are structured for disposal of the waste portion through further transport using a third gripper.

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89. (previously presented as PCT claim 55) The device of claim 76,
wherein at least one of said first and said second processing cylinders
is a hollow cylinder suitable for accepting the waste portion.